

Grey

Dart Aerospace Ltd.

Date: Tuesday, 03/02/2009 2:49:03 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 45474		
Estimate Number	: 13769		
P.O. Number	:	Part Number	: D3860041
This Issue	: 03/02/2009 S.O. No. :	Drawing Number	: D3860 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 20/02/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>SJO 09-02-03</u>		
Comment	: Est Rev:A 09-02-03 new issue DD verified by:EC		

(add one for template)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.4780 sf(s)/Unit Total : 2.8678 sf(s)
 304/316 .063 Sheet
 Batch: 110551 B9-2-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3860
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

B9-2-4

(7)

B9-2-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 09/02/05 (A7)

5.0	D30093	Cup
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)
 CUP
 Batch: B42376

EL 9-2-24 A7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45474

Part Number: D3860041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3860

A/R 316L stainless steel rod Batch: M107051 EL 9-2-24

2-Weld hard facing as per Dwg D3860

A/R 2059B Hard Coat rod Batch: 1109893 EL 9-2-25

X7

X7

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PC09.02.25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/25 X7

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 9:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 4:30am 9/1 09-02-26

X7

(7)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/26

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location: PPP 45466 + PPP 45469

09/02/26

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

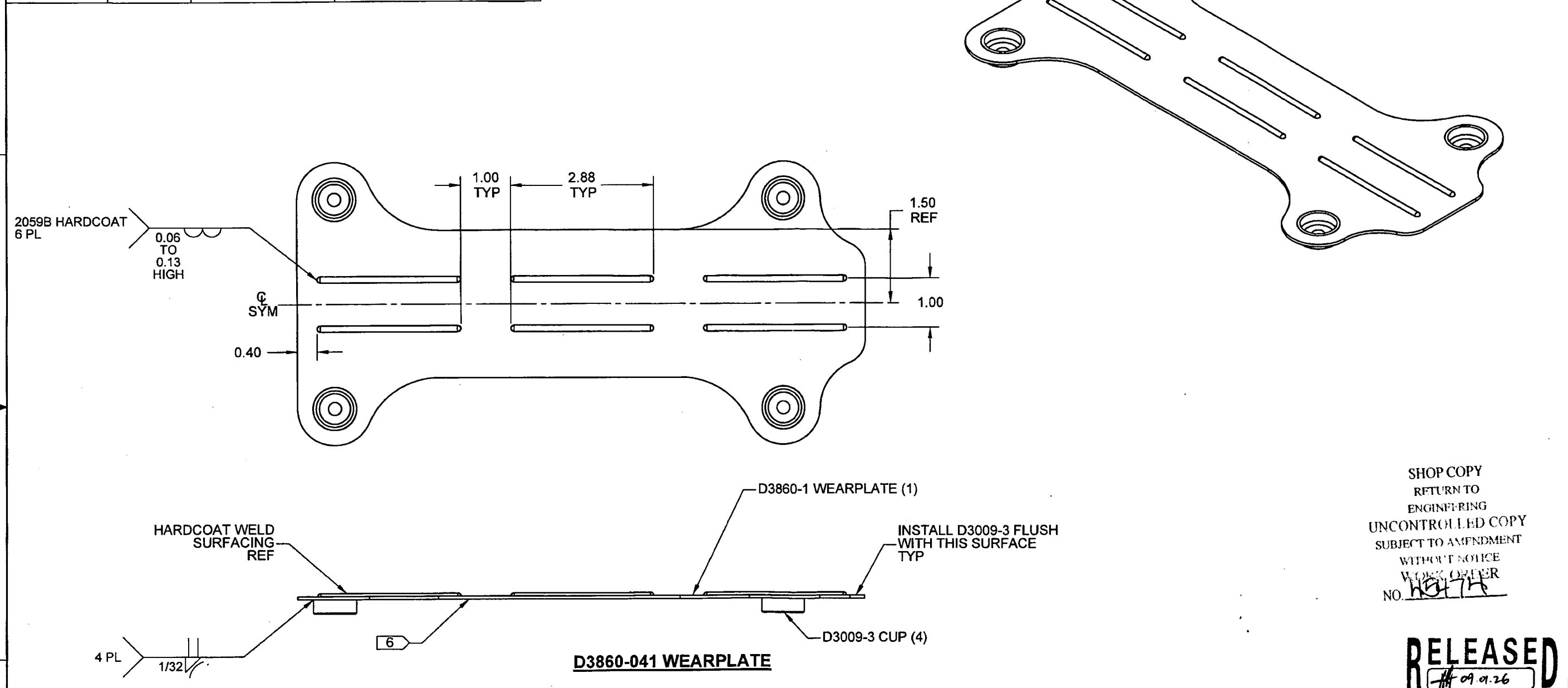
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3860-041	WEARPLATE
2	1	D3860-1	WEARPLATE
3	4	D3009-3	CUP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3860-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE	BY	09.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3860** REV. A
SHEET 1 OF 2

TITLE **WEARPLATE** SCALE NTS

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